

Date: Monday, 11/05/2009 1:21:02 PM  
 User: Julie Dawson

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services    | <b>Drawing Name</b> : BRACKET                               |
| <b>Job Number</b> : 47848                                |   |
| <b>Estimate Number</b> : 10283                           |   |
| <b>P.O. Number</b> :                                     | <b>Part Number</b> : D31991 <i>GY</i>                       |
| <b>This Issue</b> : 11/05/2009 <b>S.O. No.</b> :         | <b>Drawing Number</b> : D3199 REV B                         |
| <b>Prsht Rev.</b> : NC                                   | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : // <b>Type</b> : SMALL /MED FAB     | <b>Drawing Revision</b> : B                                 |
| <b>Previous Run</b> : 46335                              | <b>Material</b> :   |
| <b>Written By</b> :                                      | <b>Due Date</b> : 28/05/2009 <b>Qty:</b> 40 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <i>JUL09.05.11</i>    |   |
| <b>Comment</b> : Est Rev:C Removed Scribing 05-11-05 JLM |   |
| Est Rev:D As per Rev B 06-11-24 JLM                      |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
|-----|-----------|--------------------|



**Comment:** Qty.: 0.1040 sf(s)/Unit Total : 4.1580 sf(s)

304/316 0.040" SHEET

Batch: *111571 B 9-5-07*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: *B* *B 9-5-07*

Prog Rev: *B*

Deburr if required *B 9-5-07*



|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*B 9-5-07*

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

*S 09/05/28* *counter* *(42)*

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3199

*S 09/05/28* *(42)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:21:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47848

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/05/28 <sup>cont</sup> (42)

7.0

POWDER COATING

POWDER COATING



m 109091



Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:20

OVEN TEMPERATURE:

320°

FINISH TIME:

8:50

FL 02/06/03

(42)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 04-06-3 (42)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2B6A

9/6/14

(42) SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/05

Job Completion



MF 09-06-04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

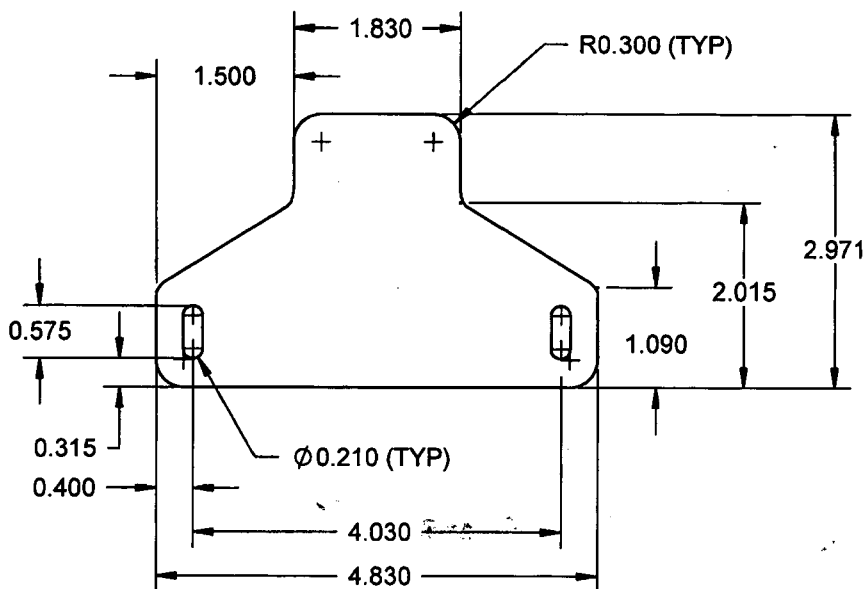
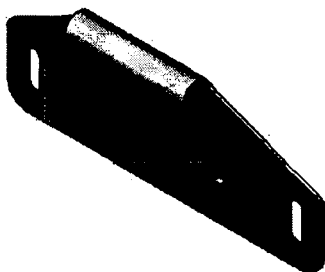
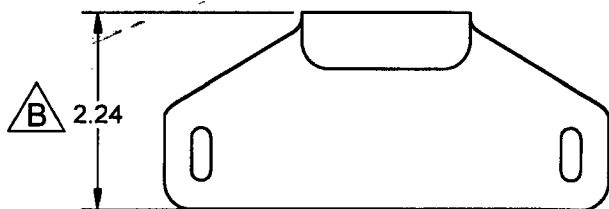
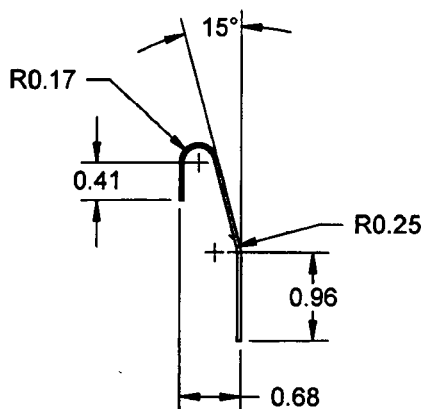
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**DART**

|                         |                                |  |                        |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>GP</i>     | DRAWN BY<br><i>CB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i>    | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3199</b>                              | REV. B<br>SHEET 1 OF 1 |
| DATE<br><b>06.11.01</b> | TITLE<br><b>BRACKET</b>        |  | SCALE<br>1:2           |
| REV                     | DATE                           | DESCRIPTION  |                        |
| A                       | 03.08.05                       | NEW ISSUE  |                        |
| B                       | 06.11.01                       | 2.24 WAS 2.142; ADD FINISH; UPDATE DWG                   |                        |

**RELEASED***06.11.20***D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *47848*

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